Work Orde Monday, July 12									:		Page 1	
Item ID: Revision ID:	D4016-1			Accept					Setup		i inniiini di	
Start Date: Required Date:	Hinge Half, B 7/12/2010 7/16/2010	Start Qty: 9.00 Req'd Qty: 9.00			Cust Ite Custom	1				Stop		
Approvals:	Process Pla	an:	Date: 10-7-0	Tooling: SPC (Y/N):		Date:	- 		Run	Start Stop	i ioekilek e	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr D4016	Rev A	vision Nbr								1	····	
100 Bandsaw Jeaspa Bandsaw		Cut blanks as per folio  Memo  CUT BLAN	IK 1.00" LONG	•	0107(93 N=			9	Ø	<u> </u>		

110

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

0.00

DEBURR

Dart Aerospace	Ltd	
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W/O:			WO	RK ORDER CHAN	IGES					
DATE	STEP	PRC	CEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									. 755 mg	
			···							
Part No	:	PAR #:	Fault Categ	ory:	NCF	R: Yes	No <b>DQA</b>		Date:	
	R	esolution:	Disposition	:	QA:	N/C CI	osed:		Date: _	
NCR:		V	WORK ORDE	R NON-CONFORI	MANCE	(NCF	R)			
DATE	STEP	Description of NC			Section B		Verifica	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Descriptio  Chief Eng	n	Sign 8 Date	Section		Chief Eng	QC Inspector
		3								
	-					<del></del>		1		
					1				<u> </u>	
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1										
NOTE: D	ate & initi	al all entries							<u> </u>	I,,-

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

### Work Order ID 60472

Monday, July 12, 2010 1:17:02 PM



Page 2

Item ID:

D4016-1

Accept

Setup Start

Stop

**Revision ID:** 

Item Name:

Hinge Half, Base

**Start Date:** 

7/12/2010

QC:

Start Qty: 9.00

**Required Date: 7/16/2010** 

Req'd Qty: 9.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Date: Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Sequence ID/

Work Center ID

120

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

130

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

160

Packaging Packaging

Memo

0.00

JC. 10.01.26

Identify as per dwg & Stock Location:

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Oty Chief Eng / Prod Mgr Prod Mgr OC Inspector I DATE STEP STEP PROCEDURE CHANGE BY Date Oty STEP Prod Mgr OC Inspector

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verifica <b>ti</b> on	Approval	Ammental	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
		. '						

NOTE: Date & initial all entries

### Work Order ID 60472

Monday, July 12, 2010 1:17:02 PM



Page 3

Item ID:

D4016-1

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Hinge Half, Base

**Start Date:** 

7/12/2010

Start Qty: 9.00

Required Date: 7/16/2010

Req'd Qty: 9.00



**Cust Item ID:** 

Customer:

Tool ID

Reference:

Approvals:

Process Plan: \_\_\_\_\_

QC:

Operation

Description

Date: \_\_\_\_\_

Date: Tooling:

SPC (Y/N):

Set Up/

Date:\_

Run Start

Reject

Qty

Stop



Sequence ID/

Work Center ID

170

QC21- Final Inspection - Work Order Release

**Run Hours** 

0.00

Date:

Tool # Plan Code

Accept Qty

Reject Number

Insp. Stamp

Memo

0.00

Quality Control

10/07/274) pl 10-7-26

# **Dart Aerospace Ltd**

									5
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	ety	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1								
Part No		PAR #:							
	Re	esolution:	Disposition	1:	_ QA: N/C C	losed:	+	Date: _	·
NCR:		,	WORK ORDE	ER NON-CONFORMA	ANCE (NC	R)			
DATE	0750	Description of NC		Corrective Action Secti		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Section		Chief Eng	QC Inspector

NOTE: Date & initial all entries

# **Picklist Print**

Monday, July 12, 2010 1:17:06 PM

Work Order ID: 60472

Parent Item: D4016-1

Parent Item Name: Hinge Half, Base

**Start Date:** 7/12/2010

Required Date: 7/16/2010

Page 1

Start Qty: 9.00 Required Qty: 9.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY:DD IPP Rev:B

as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	9.6263	0.08	0.757895			
				Location		Loc	Otv :	Loc Code					

Location MAT54 9.62630368 8.9682 108381-4 0.65810368 112752

# **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHAN	IGES				-	
DATE	STEP	PROCI	EDURE CHA	NGE	В	у	Date	Qty_	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCR: `	Yes N	lo DQA:		Date:	
	Re	esolution:	Disposition	on:	QA: N/	C Clo	sed:		Date: _	•
NCR:		W	ORK ORD	ER NON-CONFORI	MANCE (I	NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Descriptio Chief Eng		ign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
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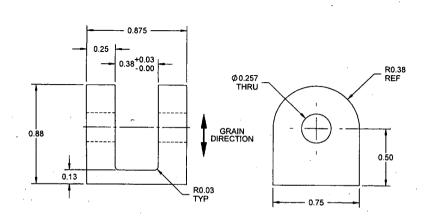
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	60472
Description: Hinge Half, Base	Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1

•	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST	. ·
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	0.876			Vern	-225-11
0.25	+/-0.030	0.239	<b>√</b> .		Vern	DIBI
0.38	+0.030/-0.000	0.395			Vern	DTPI
R0.03	+/-0.030	0.03	<b>√</b>		Rad gage	
0.13	+/-0.030	0.125			Vern	DIPI
0.88	+/-0.030	0.877			Vern	TOTPI
Ø0.257	+0.006/-0.001	0.259	1		Vern	DIDI
R0.38	+/-0.030	0.38	1	,	Rad Gage	
0.500	+/-0.030	0.498	1.		Vern.	।।भारत
0.75	+/-0.030	0.752			Vern	DRU
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easured by:	57	Audited by:			Preliminary /	Approval:
Date: 10	107/26	Date:	10/01/0	در		
ev Date C	hange		, , , , , ,		Revis	ed by Approve

Rev	Date	Change '	<b>Revised b</b> 液	Approved
Α	10.06.07	New Issue	KJ 😽	
	L		· 17)	-

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 60912 BS/10-7-12 **D4016-1 HINGE HALF, BASE** D4016-3 HINGE HALF, LID **D4016-5 HINGE HALF, LIGHT LID** RELEASE 2010 -02- 16 NEW ISSUE 10.01.29 REV. **ESCRIPTION** DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN AJS CHECKED REV. A D4016 MFG. APPR. APPROVED **BASKET HINGE** DE APPR. 10.01.29



D4016-1 HINGE HALF, BASE

**D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID** 

GRAIN DIRECTION 0.88

R0.03

- 0.563 -

0.50

- 0.13

0.63

0.13

0.250

R0.31 REF

Ø0.257 THRU

DESIGN	AJS	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARK			
CHECKED	(1)	DRAWING NO.	REV. A		
MFG. APPR.	N	D4016	SHEET 2 OF 2		
APPROVED	10	TITLE	SCALE		
DE APPR.		BASKET HINGE	NTS		
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMEN'S IS PRIMATE AND COMPEDITION, AND IS SUPPLED ON THE EMPESS CONCERN WITHOUT NOT TO BE URED FOR ANY PARROSE OR COMPED OR COMPENSACRET TO ANY OTHER PERSON WITHOUT			

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs -5: 0.01 lbs